

# Work Order ID 86450

\*86450\*

Page 1

Friday, June 29, 2012 10:52:39 AM

Item ID: D4422-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Shim

Stop \*NS2\*

Start Date: 6/29/2012 Start Qty: 5.00 \*5\*

Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 5.00 \*5\*

Customer:

Reference: ALODINE *Rework*

Approvals: Process Plan: *mmf* Date: *12-06-29* Tooling:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4422

A

140	Chemical Conversion Coat per QSI005 4.1	0.00
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\*140\*

HandFinish

Memo

0.00

Hand Finishing

PULL FROM STOCK D4422-1 X 5 80924 AND ALODINE

*5 NG 12-7-3*

150	QC7-Inspect Chemical Conversion Coat	0.00
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\*150\*

QC

Memo

0.00

Quality Control

*8/17/07/24*

*58*

160	Identify as per dwg & Stock Location <i>5-111</i>	0.00
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\*160\*

Packaging

Memo

0.00

Packaging

*5x*

*80 12-7*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 86450**

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Item ID: D4422-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Shim

Stop **\*NS2\***

Start Date: 6/29/2012 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 5.00

**\*5\***

Customer:

Reference: ALODINE

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

12/7/4

16-074

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 29, 2012 10:52:38 AM

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Work Order ID: 86450

Parent Item: D4422-1

Parent Item Name: Shim

Start Date: 6/29/2012

Required Date: 7/3/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP revA 11.06.30 new issue ec verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4422-1 Shim		Manufactured	No				Each	10.0000		5			

Location

Loc Qty

Loc Code

ST139d

10

86448

10

5X 80924 MF 12-06-29

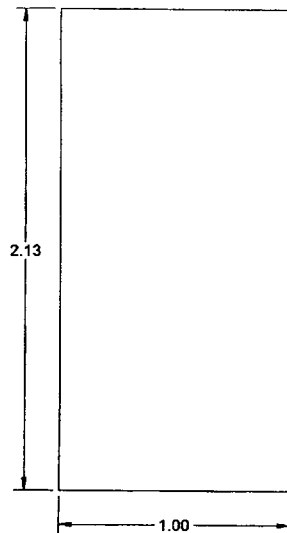
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



**D4422-X SHIM**



P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

**NOTES:**

**1) MATERIAL:**

D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11  
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.125

OR

6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8  
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B

D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11  
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1

7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

**RELEASED**  
2011-07-06

A	NEW ISSUE	MB	11.06.22
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4422	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SHIM	NTS
DATE	11.06.22	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries